

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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		OTHER : ☐																																																																					

Work Order ID 155052***155052***

Page 2

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Item ID: D407-559-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: 206L Series/407 Bearpaws - Large

Start Date: 1/12/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/26/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD407-559-113
LOCATION: FG015

2

Smb

1/13/17

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.03

Quality Control

DAS
21
9-89

MAR 03 2017

DAS
21
9-89
MAR 03 2017

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 155052

155052

Parent Item: D407-559-113

D407-559-113

Parent Item Name: 206L Series/407 Bearpaws - Large

Start Date: 1/12/2017

Required Date: 1/26/2017

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD 09.10.29 verified by:EC
IPP RevB: ECN09-698p DD 09.11.03 verified by:EC
as per revision K DD 09.11.24 verified by:EC
per ECN10-575 DD ver:EC
IPP RevC:
IPP Rev:D 10.05.27
IPP REV:E 11-04-11 PER INN REV L JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2274		Manufactured	No			160	Each	655.0000	16	32			
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D2274

Radius Block

**

DAS 6 9-89 MAR 01 2017

DAS 27 9-89

Location	Loc Qty	Loc Code
----------	---------	----------

FG	12	
86855	12	
ST006	340	
150353	1	
151763	339	
ST012a	303	
152449	303	

32

D3456-1

D3456-1

Washer

Manufactured No

160	Each	88.0000	8	16
-----	------	---------	---	----

**

DAS 6 9-89 MAR 01 2017

DAS 27 9-89

Location	Loc Qty	Loc Code
----------	---------	----------

FG	7	
25701	7	
ST037	31	
151938	31	
ST038A	50	
152842	50	

155548

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								Completed By	
								Lead hand / Supervisor Approval Verification	
QC / QA Coordinator Approval									

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
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Page 2

Work Order ID: 155052

155052

Parent Item: D407-559-113

D407-559-113

Parent Item Name: 206L Series/407 Bearpaws - Large

Start Date: 1/12/2017

Required Date: 1/26/2017

Start Qty: 2.00

Required Qty: 2.00

S
12
D4011-1
D4011-1
Clamp, Short

Manufactured No 160 Each 90.0000 8 16

**

MAR 04 2017

DAS
6
27
9-89

Location	Loc Qty	Loc Code
ST544	90	
152409	50	
154151	40	

155088

S
12
D4011-5
D4011-5
Clamp, Short

Manufactured No 160 Each 30.0000 8 16

**

MAR 04 2017

DAS
6
27
9-89

Location	Loc Qty	Loc Code
ST542	30	
132223	18	
132624	12	

1324

S
12
D4012-1
D4012-1
Cushion

Manufactured No 160 Each 37.0000 8 16

**

MAR 04 2017

DAS
6
27
9-89

Location	Loc Qty	Loc Code
FG	5	
133458	5	
ST545	32	
151752	1	
152436	31	

132227

S
12
D4355-1
D4355-1
Bearpaw

Manufactured No 160 Each 2.0000 2 4

**

MAR 04 2017

DAS
6
27
9-89

Location	Loc Qty	Loc Code
ST470A	2	
150250	2	

155091 x12

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Work Order ID: 155052

155052

Parent Item: D407-559-113

D407-559-113

Parent Item Name: 206L Series/407 Bearpaws - Large

Start Date: 1/12/2017

Required Date: 1/26/2017

Start Qty: 2.00

Required Qty: 2.00

D4360-041

Manufactured No

160 Each

5.0000

2 4

DAS 6

9-89

MAR 01 2017

D4360-041

Wearplate Assembly

**

Location

Loc Qty

Loc Code

ST605

5

102873

5

24

DAS 6

9-89

MAR 01 2017

AN4C11A

Purchased No

160 Each

33.0000

8 16

DAS 6

9-89

MAR 01 2017

AN4C11A

Bolt

**

M136602X14

Location

Loc Qty

Loc Code

ST344

33

m134370

33

2

DAS 6

9-89

MAR 01 2017

AN4C20A

Purchased No

160 Each

28.0000

16 32

DAS 6

9-89

MAR 01 2017

AN4C20A

Bolt

**

M13686X4

Location

Loc Qty

Loc Code

OVER002

25

M128429

25

25

ST312A

3

M128818

3

2

DAS 6

9-89

MAR 01 2017

AN4C21A

Purchased No

160 Each

56.0000

16 32

DAS 6

9-89

MAR 01 2017

AN4C21A

BOLT

**

Location

Loc Qty

Loc Code

OVER002

50

M129390

50

26

ST312A

6

M129384

6

6

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							Lead hand / Supervisor Approval Verification		
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Parent Item: D407-559-113

D407-559-113

Parent Item Name: 206L Series/407 Bearpaws - Large

Start Date: 1/12/2017

Required Date: 1/26/2017

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

160

Each

1,376.000

24

48

MS21043-4

Nut

**

DAS 6 9-89 MAR 04 2017 27 9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

OVER007

900

m136192

300

m136263

300

m136406

300

ST302

419

m135600

19

m136148

400

NAS1149D0463J

Purchased

No

160

Each

3,549.000

16

32

NAS1149D0463.J

Washer

**

DAS 6 9-89 MAR 07 2017 27 9-89

Location

Loc Qty

Loc Code

GA

80

M134508

13

M135056

67

ST260a

2200

M136192

600

M136263

600

M136406

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Friday, January 06, 2017 1:47:51 PM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

REFERENCE ONLY

DART AEROSPACE LTD.

D206-559

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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Revision: **L**
Date: 11.04.08

Change Record

PAGE 1 OF 1

Part Number: D407-559-113

Description: BEARPAW INSTALLATION

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
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				Completed By			
				Lead hand / Supervisor Approval Verification			
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
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